



Dart Aerospace Ltd.
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D5155-3**Job Sheet 191833****Part No:** D5155-3**Job Qty:** 6 pcs**Part Name:** Co-Pilot Collective Head (212)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 3/11/19**Job Tracking No:****Due Date:** 3/29/19 *04/12/2019***Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV B IPP REV.A NEW ISSUE JFS 15/01/14 VERIFIED BY: JLM IPP REV:B 15.07.02 AS PER DWG
REV.B DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	3/29/19	3/29/19	0.00	0.23	Bandsaw - 1		<i>SM</i>
110	HAAS 5 Axis - B4B	6 pcs	3/29/19	3/29/19	0.78	17.14	HAAS - 5 - B4B		<i>19-04-09</i>
120	QC 1	6 pcs	3/29/19	3/29/19	0.00	0.00	QC 1 - 14		
							QC 1 - 35		
							QC 1 - 8		
							QC 1 - 9		
130	QC 8	6 pcs	3/29/19	3/29/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
160	Packaging 3-1 - Stock - B4B	6 pcs	3/29/19	3/29/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

**Container No:** S169084**Part:** D5155-3**Job No:** 191833**Serial No/Batch:** S169084**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 04/03/19

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					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	12
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	6 pcs	3/29/19	0.00 0.00	QC 21 - SA - 21	0.46
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9.89
Part Op 100 - CUT BLANK AT 5.000" Descriptions: 110 - (HAAS CNC vertical machine #5), MACHINE AS PER DWG & FOLIO FB349/ D5155-3 120 - (QC1- Inspection performed by CMM), Inspect on CMM as per folio CMMA032. 130 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: <i>WAOY</i>) 170 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M6061T6B4.500X4.500	6061-T6 Aluminumbar 4.500" X 4.500" (CUT IN SECTION 6ft)	2.5020 ft (.417 ea)	100-Bandsaw - 1	S121736		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Bandsaw - 1	M6061T6B4.500X4.500	3	11	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order:	191833
Description: Co-Pilot Collective Head (212)		Part Number:	D5155-3
Inspection Dwg: D5155	Rev: B	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.33	+/-0.030	.327	✓		SLIO	Vern
0.06	+/-0.030	.063	✓		"	
0.35	+/-0.030	.349	✓		"	
4.700	+/-0.010	4.700	✓		"	
2.800	+0.010/-0.000	2.8052	✓		Height gauge	
R0.19	+/-0.030	.190	✓		Rad gauge	
0.35	+/-0.030	.347	✓		SLIO	
2.547	+/-0.005	2.549	✓		"	
21°	+/-0.5°	21°	✓		Protractor	
Ø0.125 x 0.350	+0.004/-0.001 x +/-0.010	.126 x .350	✓		SLIO	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.850	+/-0.010	1.846	✓		Height gauge	
0.227	+/-0.010	.225	✓		SLIO	
Ø0.188 x 100°	+/-0.010 x +/-0.5°	.190 x 100°	✓			
Ø0.116	+0.004/-0.001	.120	✓			
1.188	+/-0.005	1.190	✓			
1.92	+/-0.030	1.920	✓			
1.50	+/-0.030	1.501	✓			
2.400	+/-0.005	2.401	✓			
0.300	+/-0.010	.300	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
Ø0.150	+0.005/-0.001	.154	✓		SLIO	
3.000	+/-0.010	3.000	✓			
R0.30	+/-0.030	.300	✓			
R0.25	+/-0.030	.250	✓			
1.350	+/-0.010	1.351	✓			
1.750	+/-0.010	1.752	✓			
1.350	+/-0.010	1.351	✓			
1.00	+/-0.030	1.000	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
10°	+/-0.5°	10°	✓		Protractor	
0.25	+/-0.030	.248	✓		SLIO	
R0.30	+/-0.030	.300	✓		Rad gauge	
2.500	+/-0.010	2.503	✓		SLIO	
2.70	+/-0.030	2.702	✓			
Ø0.150	+0.005/-0.001	.154	✓			
Ø0.627	+0.008/-0.001	.627	✓			
Ø1.187	+0.005/-0.000	1.190	✓			
Ø1.660	+/-0.010	1.659	✓			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					